

**Work Order ID 62817**

Friday, October 08, 2010 12:45:57 PM

Page 1

Item ID: D2364

Accept

Setup Start

Revision ID:

Stop

Item Name: Deck Plate, Fwd 350 Litt

Start Date: 10/8/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date: 10-10-08

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2364

Rev F

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2364  
Deburr if necessary☐ Dwg Rev:

F

☐ Prog Rev:

F

☐ 2-

10-10-18

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-10-19

120

QC8- Inspect parts - second check

0.00



QC

Memo

JM-03

0.00

Quality Control

3


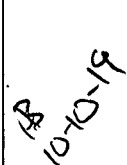



1

10-10-19

870

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 2364 PAR #: \_\_\_\_\_ Fault Category: Small Fds/w-Jet NCR: Yes No DQA: \_\_\_\_\_ Date: 10/10/19  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: \_\_\_\_\_ Date: 10/10/28

NCR: 62817		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/10/19	100	1 part has minor pressure blow outs in 2 holes (rivet holes).  R.C. process		Scrap & no replace	 10/10/19	 10/10/19	 10/10/19	 10/10/19

NOTE: Date & initial all entries

**Work Order ID 62817**

Friday, October 08, 2010 12:45:57 PM



Page 2

Item ID: D2364

Accept



Setup Start



Revision ID:

Stop



Item Name: Deck Plate, Fwd 350 Litt

Start Date: 10/8/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- counter sink holes as per dwg D2364-2- deburr if necessary

EP 10/10/2010 (3)

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

SP 10/10/2010 (3)

150

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

=> MJ 10/10/2010 3 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 62817

Friday, October 08, 2010 12:45:57 PM



Page 3

Item ID: D2364

Accept



Setup Start



Revision ID:

Stop



Item Name: Deck Plate, Fwd 350 Litt

Start Date: 10/8/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

M112588

Memo

0.00

Powder Coating

START TIME:

11:30

OVEN TEMPERATURE:

FINISH TIME:

12:00

3

BL 10-10-27.

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> M

10/10/27

3

Ø

180

Identify as per dwg & Stock Location:

225

0.00



Packaging

Memo

0.00

Packaging

10/10/27 (32) SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 62817**

Friday, October 08, 2010 12:45:57 PM

Page 4

Item ID: D2364

Accept

Setup Start

Revision ID:

Stop

Item Name: Deck Plate, Fwd 350 Litt

Start Date: 10/8/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/28  
MF  
10-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Friday, October 08, 2010 12:46:02 PM

Page 1

Work Order ID: 62817



Parent Item: D2364



Parent Item Name: Deck Plate, Fwd 350 Litt

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. E 00.06.26 Removed P/O for powder coat EC  
IPP Rev:F Now On Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.063

Purchased

No

100

sf

104.8000

0.6469

2.723789



HR10-10-18

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT22

104.8

113866

15.5

114351

89.3

113866

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	42817
<b>Description:</b> Litter Deck Plate Kit (350)		<b>Part Number:</b>	D2364
<b>Inspection Dwg:</b> D2364	<b>Rev:</b> F	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.622	X		V 1B02	
Ø0.171	+0.005/-0.000	.173	X		V	
0.354	+/-0.010	.353	X		V	
11.242	+/-0.010	11.244	X		V PRO 1B02	
3.031	+/-0.010	3.033	X		V	
1.903	+/-0.010	1.901	X		V	
1.128	+/-0.010	1.128	X		V	
0.354	+/-0.010	.355	X		V	
1.340	+/-0.005	1.335	X		V	
2.326	+/-0.010	2.322	X		V	
3.312	+/-0.010	3.318	X		V	
4.298	+/-0.010	4.296	X		V	
5.284	+/-0.010	5.285	X		V	
6.151	+/-0.010	6.151	X		V	
6.270	+/-0.010	6.270	X		V	
0.354	+/-0.010	.353	X		V	
3.031	+/-0.010	3.033	X		V	
Ø0.656	+0.005/-0.000	.656	X		V	
5.003	+/-0.010	5.003	X		V	
4.605	+/-0.010	4.603	X		V	
1.776	+/-0.010	1.776	X		V	
0.980	+/-0.010	.980	X		V	
4.487	+/-0.010	4.490	X		V	
7.192	+/-0.010	7.195	X		V	
7.567	+/-0.010	7.570	X		V	
7.942	+/-0.010	7.941	X		V	
Ø0.191	+0.005/-0.000	.193	X		V	
Ø0.197	+0.005/-0.000	.199	X		V	
11.145	+/-0.010	11.150	X		V PRO 1B02	
12.181	+/-0.010	12.181	X		T 1B01	
11.378	+/-0.010	11.376	X		V PRO 1B02	
11.776	+/-0.010	11.777	X		V PRO 1B02	
12.173	+/-0.010	12.173	X		T	
4.690	+/-0.010	4.692	X		V	
Ø 0.250	+0.005/-0.000	.249	X		V	
3.141	+/-0.010	3.136	X		V	
Ø 0.171	+0.005/-0.000	.173	X		V	

<b>Measured by:</b> IB	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-10-18	<b>Date:</b> 10/10/19	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	08.05.28	7.567 dimension revised	KJ/DD [Signature]	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

SHO...  
R...  
ENGINE...  
UNCONT...  
SUBJECT...  
WITH...  
WOL...  
NO 62817

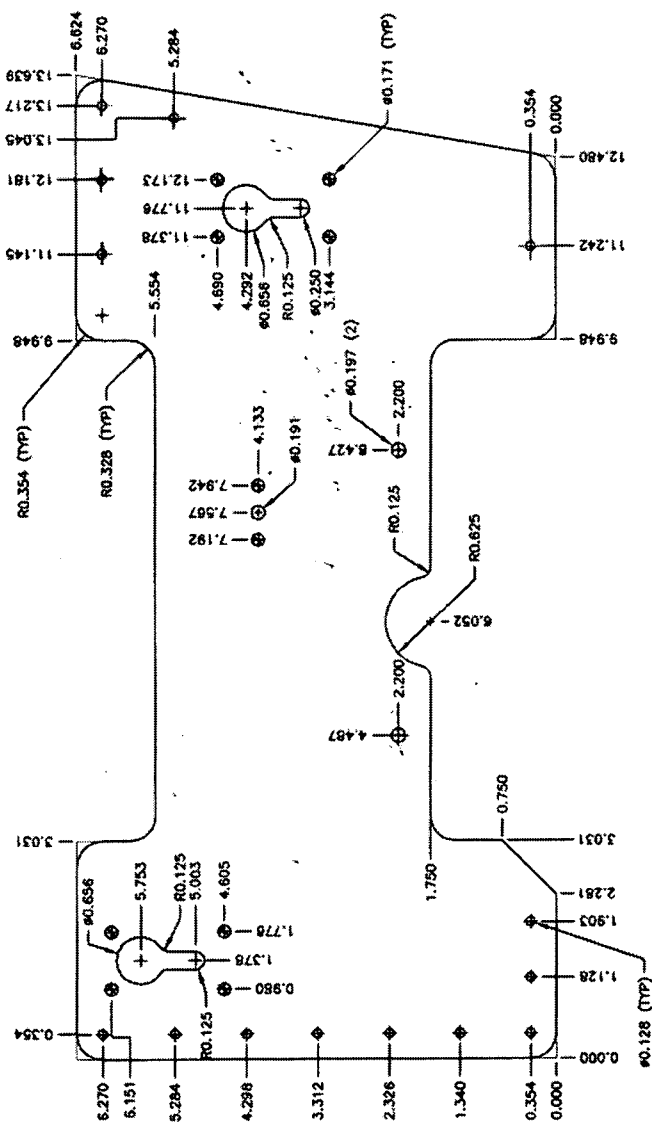


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2364	REV. F SHEET 1 OF 1
DATE 98.06.19	TITLE LITTER DECK PLATE, 350		SCALE 2:5
A	95.01.14	NEW ISSUE	
B	95.02.09	MOVED KEYWAY	
D	95.03.06	0.191 WAS 0.197	
E	95.10.06	GEOMETRY CHANGES	
F	98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)	

RELEASED  
99/06/22 KE

COUNTER SINK HOLES: (UPDATED FROM 9 TO 14 HOLES BY DS 99.03.01 TO CORRECT CAD ERROR)

- ◆ C'SINK Ø0.225 x 100°
- C'SINK Ø0.308 x 100°



MATERIAL: 2024-T3 (QQ-A-250/5) 0.063-0.071 THICK  
FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries